

Covered Electrodes

KH-500LF

For 490MPa high tensile steel

Classifications

EN ISO 2560-A:2006	: E 38 3 B 12 H10	KS D 7004	: E4316
EN ISO 2560-B:2006	: E 43 16 A U H10	JIS Z 3211	: E4316
AWS A5.1-04	: E7016		

Description

- Covering is low hydrogen type for welding of strength members of ship hulls and general heavy structural steels, medium carbon steel, high sulphur steel. Underlying of hardfacing.
- Excellent mechanical properties and radiographic soundness.
- Excellent crack resistance even in the welding of difficult to weld steels.
- Redry the electrode at 300~400°C for 1~2 hours prior to use.

Welding positions



Typical chemical composition of all-weld metal (%)

C	Si	Mn*	P	S	Ni*	Cr*	Mo*	V*	*Sum
0.07	0.46	0.96	0.015	0.011	0.02	0.03	0.01	0.01	1.03

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				-20°C	-30°C	
JIS Z 3211	min. 330	min. 430	min. 20		≥ 27	
EN ISO 2560-A	min. 380	470~600	min. 20		≥ 47	
Example	460	540	28	120	100	AW

* AW : As-Welded

Sizes available and recommended currents (AC or DC +)

Dia.	(mm)	2.6	3.2	4.0	5.0	6.0
Length	(mm)	350	350	400	400	450
Amp. (A)	F V · OH	60~90 50~80	90~130 80~110	140~190 120~160	180~240 160~200	250~300 -

Approvals

ABS	BV	DNV	GL	KR	LR	NK
3YH10	3YHH	3YH10	3YH10	3YH15	3YmH15	KMW3H

* Others : KS, JIS, CE